

Dur 60

CATEGORY	SMAW Stick Electrodes				
TYPE	Rutile coated, high recovery hardfacing electrode, chromium carbide based.				
APPLICATIONS	57-61 HRc, for wear resistant hardfacing layers that are subject to high abrasion and medium impact.				
PROPERTIES	Outstanding alloy against high abrasion when subjected to grinding and medium impact levels. Very good weld deposit appearance and outstanding welding properties on both AC and DC+. <ul style="list-style-type: none"> • Preheating is not required. 				
CLASSIFICATION	AWS	A 5.13: E FeCr-A1			
	EN ISO	14700: E Fe14			
	DIN	8555: E10-UM-60-GRZ			
SUITABLE FOR	Slag crushers, Sugar cane knives, hammers, Mixer blades, Digger teeth, Guides, Coal mining, Cement mixers etc..				
APPROVALS	CE approved				
WELDING POSITIONS:					
WELD METAL ANALYSIS %	C	Cr	Fe		
	3.5-4.2	28-32	Rem		
MECHANICAL PROPERTIES	Heat Treatment	RP0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Hardness HRc
	AW				57-61
AW: as welded					
WELDING PARAMETERS / PACKING	Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A) DC+/AC		kg / can	kg / 6 pack
2.5	350	80-120		2.6	15.6
3.2	350	100-160		2.5	15
4.0	450	160-220		2.5	15
REDRYING TEMPERATURE	320°C/2h				
EQUIVALENT	FCAW - OA 61 - OA 58				